

633-011

Dart Aerospace Ltd.

38

Date: Thursday, 8/30/2007 3:49:23 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT  
 Job Number : 34346A  
 Estimate Number : 10176  
 P.O. Number :  
 This Issue : 8/30/2007 S.O. No. :  
 Prsht Rev. : NC Part Number : D2563  
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2563 REV C  
 Previous Run : 32945A Drawing Revision : C  
 Material :  
 Due Date : 9/21/2007 Qty: 10 Um: Each  
 Written By :  
 Checked & Approved By : HA 07.08.31  
 Comment : Est Rev G 02.07.31 Re-format Location RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2244116 Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: BQ8216(SX) 8 33733(S) 07.09.26 10

2.0 D267334 End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part No. Description  
 2 D2673-34 End Cap

Batch

332404 07.09.26 10

3.0 D2561 Lug Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part No. Description  
 2 D2561 Lug Plate

Batch

332403 07.09.26 10

4.0 D2564 Mounting Angle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part No. Description  
 2 D2564 Mounting Angle

Batch

332460 07.09.26 10

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 8/30/2007 3:49:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 34346A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

2-Deburr ends

3-Weld (1 End CAP,LUG PLATES & MOUNTING ANGLE as per Dwg D2563 using DT 8343

A/R AL ROD

Batch:

M103794

M105058

4-Grind

A.M. 02.10.01

PE 07.09.26 10

PE 07.09.26 10

PE 07.09.27 10

(10)

6.0

DO NOT USE

WELD INSPECTION



Comment: WELD INSPECTION

QC9

QC5

PD 07-10-01 (10)

02/10/01 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M. 02.10.01

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 07/10/02 (10)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remainig End as per Dwg D2563 using DT 8343

A/R AL ROD

Batch:

M103794

3-Grind

A.M. 02.10.09

PE 02.10.04 10

PE 02.10.04 10

(10)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-09 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 3:49:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 34346A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/09 (410)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L Alodine 07/10/09 (10X)

M-L 07/10/10 (10X)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

m105694

FL 07/10/10 (10)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/10/15 SP (16X)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.16

Job Completion



U 07.10.16

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

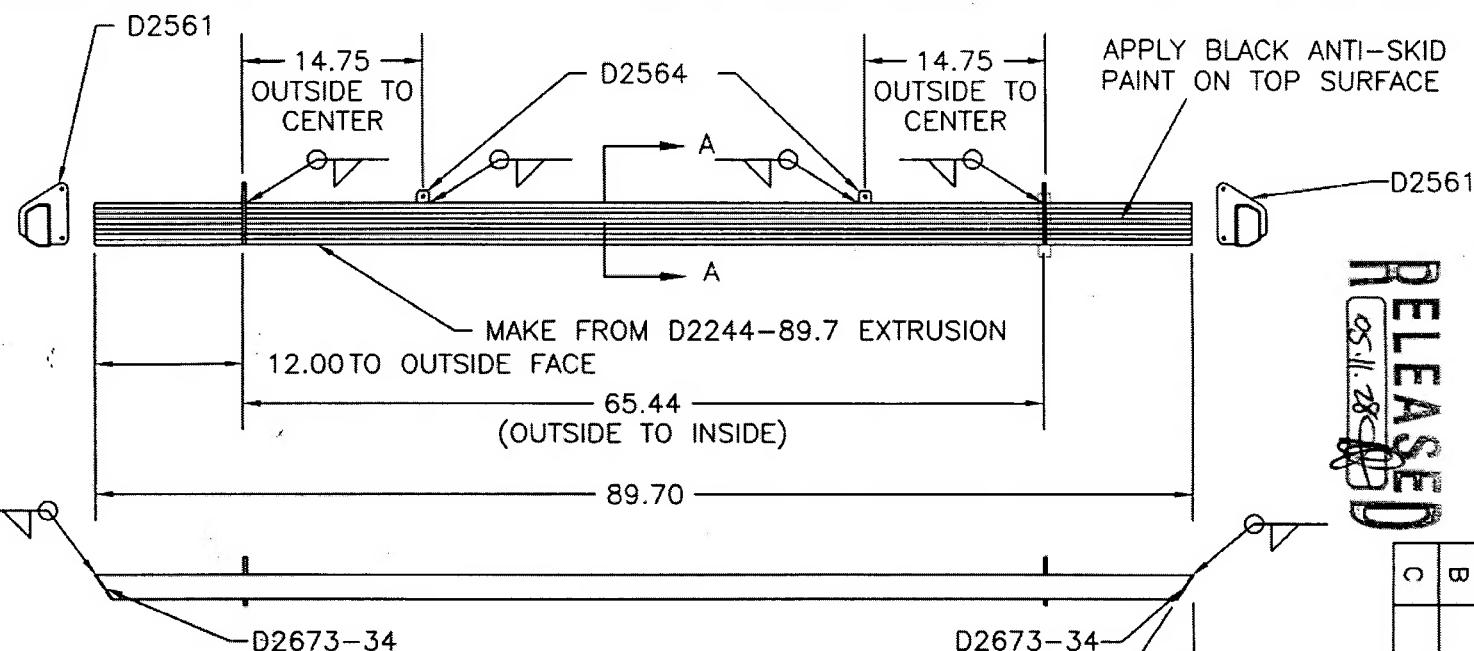
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
05.11.28

DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		H		HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. C
				D2563	SHEET 1 OF 1
DATE	05.11.14	TITLE	STEP WELDMENT ASSEMBLY	SCALE	1:15
A	96.04.26	NEW ISSUE			
B	97.05.14	END CAPS CHANGED (WAS D2248)			
C	05.11.14	UPDATE NOTES			



**D2563 STEP WELDMENT ASSEMBLY PARTS LIST**

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

cut per  
WORK ORDER  
3434A  
NO. 3434A  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENTS  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

**D2563 STEP WELDMENT ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED